

Work Order ID 97018 - 2

February-14-13 1:07:53 PM

97018

Page 1

Item ID: D4406-043

Revision ID:

Item Name: Aft Wearplate Assembly

Start Date: 2/13/13

Start Qty: 4.00

Required Date: 3/08/13

Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLC

Date: 13-02-15 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4406

PCT

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg D4406-3

prog rev: B

dwg rev: B

2-Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

042
05
13-02-23

042
05
13-02-24

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Page 2

Item ID: D4406-043

Revision ID:

Item Name: Aft Wearplate Assembly

Start Date: 2/13/13 Start Qty: 4.00

Required Date: 3/08/13 Req'd Qty: 4.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

Form as per dwg D4406

140

0.00

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

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Item ID: D4406-043

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Required Date: 3/08/13 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

150

Large Fab

Large Fab

Memo

Weld bar as per dwg
A/R 2059b hardcoat Batch#: M124842

Weld bar to wearplate as per dwg
A/R s.s. rod Batch #: M118161

② EL 13-3-11

160

160

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

CL 13-3-11

2x

165

165

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS 16 13/3/11

72

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Page 4

Item ID: D4406-043

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Start Date: 2/13/13 Start Qty: 4.00

Required Date: 3/08/13 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

170

170

Small Fab

Small Fab

Memo

Apply coating as per dwg D4406

123887

0.00

0.00

2

0

0

13-3-11

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS
16
2-83 13/3/12

12

190

190

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

SNIP

0.00

0.00

4/3/12 2

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Page 5

Item ID: D4406-043

Revision ID:

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Start Date: 2/13/13 Start Qty: 4.00

Required Date: 3/08/13 Req'd Qty: 4.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MCS 13-03-12

MF

13-3-12

Picklist Print

February-14-13 10:45:08 AM

Page 1

Work Order ID: 97018

Parent Item: D4406-043

Parent Item Name: Aft Wearplate Assembly

Start Date: 2/13/13

Required Date: 3/08/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD
revPB1 DD verf:EC

IPP rev B 12.02.06 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-3 Bar		Manufactured	No			150	Each	12.0000	2	8			

13-3-7

M304S18GA
304/316 .050 Sheet

Purchased

No

Location

WA001

Loc Qty

12

Loc Code

12

100

sf

495.4299

2.92

12.294737

Location

MAT019

Loc Qty

221

Loc Code

117188

5

117766

5

120604

5

122325

3

123155

3

124572

200

MAT020

274.429894

120243

2

121626

1.529894

124029

270.9

13-02-23

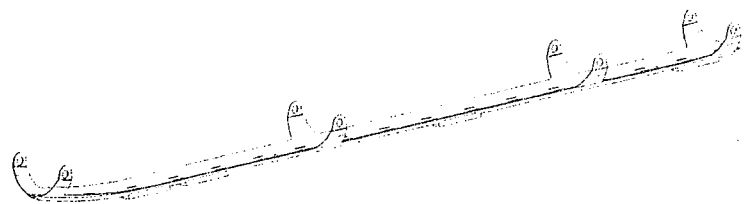
DART AEROSPACE LTD		Work Order:	97018
Description: Plate		Part Number:	D4406-3
Inspection Dwg: D4406	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

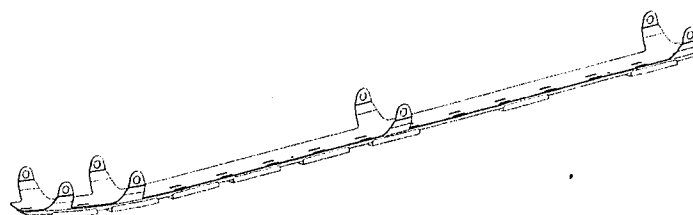
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.30	+/-0.030	0.30	✓		Visual	" "
0.88	+/-0.030	0.88	✓		Visual	" "
0.13	+/-0.030	0.13	✓		Visual	" "
0.31	+/-0.030	0.31	✓		Visual	" "
24.995	+/-0.010	24.995	✓		Visual	Sketch-22
47.958	+/-0.010	47.958	✓		Visual	" "
54.178	+/-0.010	54.178	✓		Visual	" "
2.43	+/-0.030	2.433	✓		Visual	Sketch-21
7.77	+/-0.030	7.77	✓		Visual	" "
7.203	+/-0.010	7.203	✓		Visual	" "
3.63	+/-0.030	3.63	✓		Visual	" "
4.00	+/-0.030	4.00	✓		Visual	" "
7.071	+/-0.010	7.071	✓		Visual	" "
7.800	+/-0.010	7.800	✓		Visual	" "
0.050	+/-0.010	0.050	✓		Visual	" "

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	13.10.08	Date:	13.10.08	Date:	

Rev	Date	Change	Revised by	Approved
A	11.10.13	New Issue P/O D4406-043	KJ	
B	12.03.08	Dimensions revised per Dwg Rev B	KJ	<i>[Signature]</i>



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

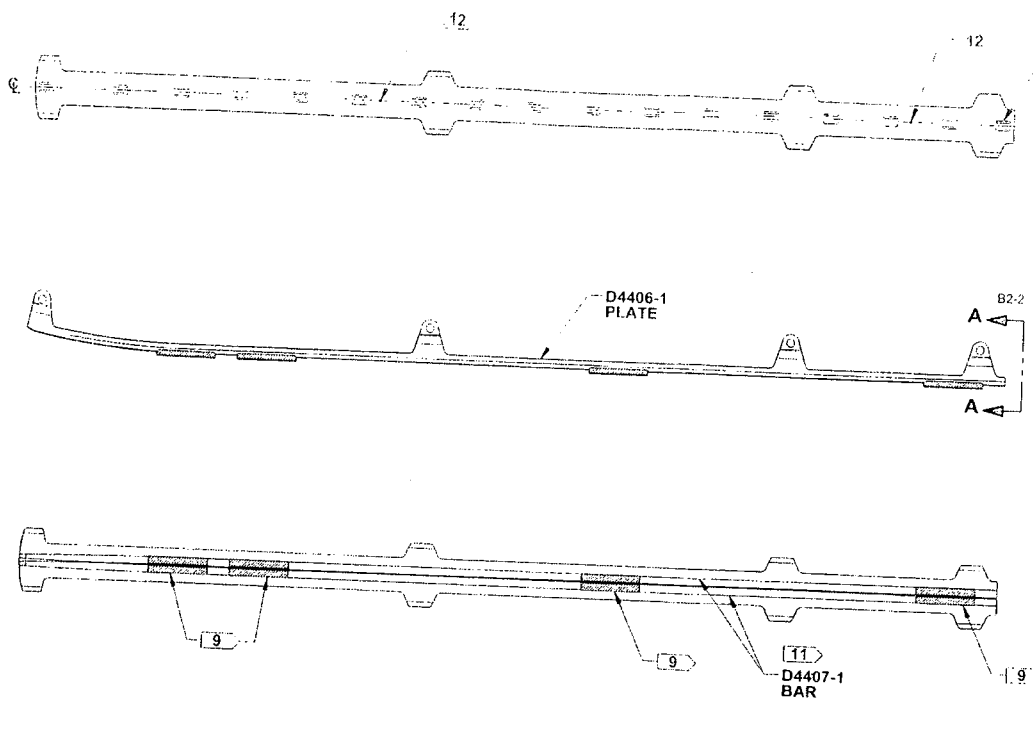
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4	1		D4406-3	PLATE
5	2		D4407-1	BAR
6	2		D4407-3	BAR
7	A/R	A/R	20598	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

97018 MLO
13-02-15

RELEASE
2012-02-23
MD

B		REVISE BILL OF MATERIAL: ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3, MODIFY DETAIL E & F (ZIN B3-6, C2-6); ADD DETAIL G (ZIN C7-6); REVISE D4406-3F TAB LOCATIONS (ZIN B5-5)	RF	12 02 16
A		NEW ISSUE	RF	11 08 15
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4406 REV. B SHEET 1 OF 6 TITLE WEARPLATE ASSY SCALE NTS DATE 12.02.16 <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON A NON-REPRODUCTION BASIS. IT IS NOT TO BE USED FOR ANY PURPOSES OR CIRCUMSTANCES NOT INTENDED BY DART AEROSPACE LTD.</small>		
DRAWN	RF			
CHECKED	RF			
MFG. APPR.	RF			
APPROVED	RF			
DE APPR.	RF			

97011



D4406-041 FWD WEARPLATE ASSY

SECTION A-A C3-2
SCALE 2X

RELEASED
2012-02-23
MP

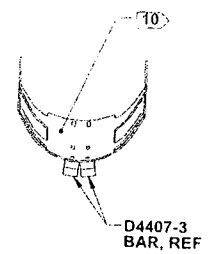
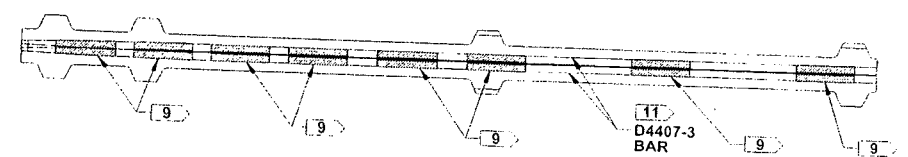
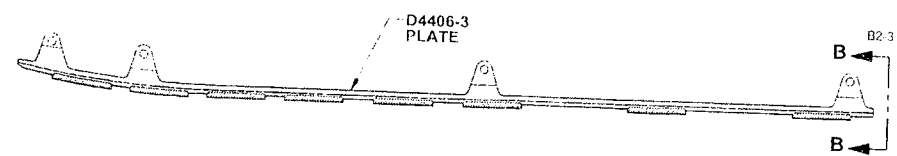
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 8.40 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
 - 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
 - 12) TRANSFER \varnothing 0.188 HOLES FROM D4406-1 TO D4407-1
 - 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

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MFG. APPR.	RF	D4406	SHEET 2 OF 6
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97012



TYP



D4406-043 AFT WEARPLATE ASSY

SECTION B-B C3-3
SCALE 2X

RELEASE
2012-02-23

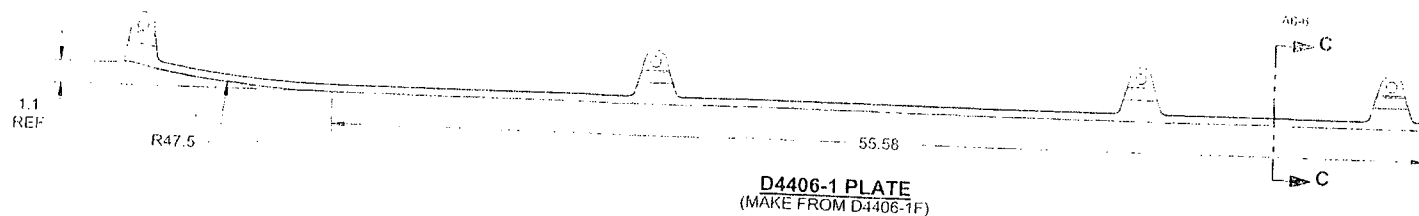
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 8.73 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
 - 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
 - 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
 - 13) TRANSFER \varnothing 0.188 HOLES FROM D4406-3 TO D4407-3
 - 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

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B

8 7 6 5 4 3 2 1

9701



D4406-1F FLAT PATTERN

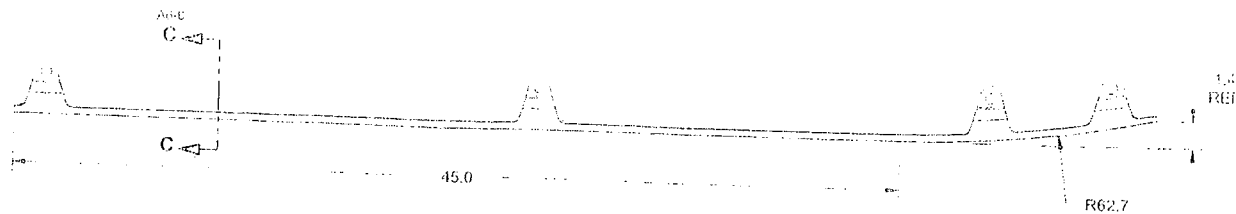
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2012-02-23
JMP

NOTES:

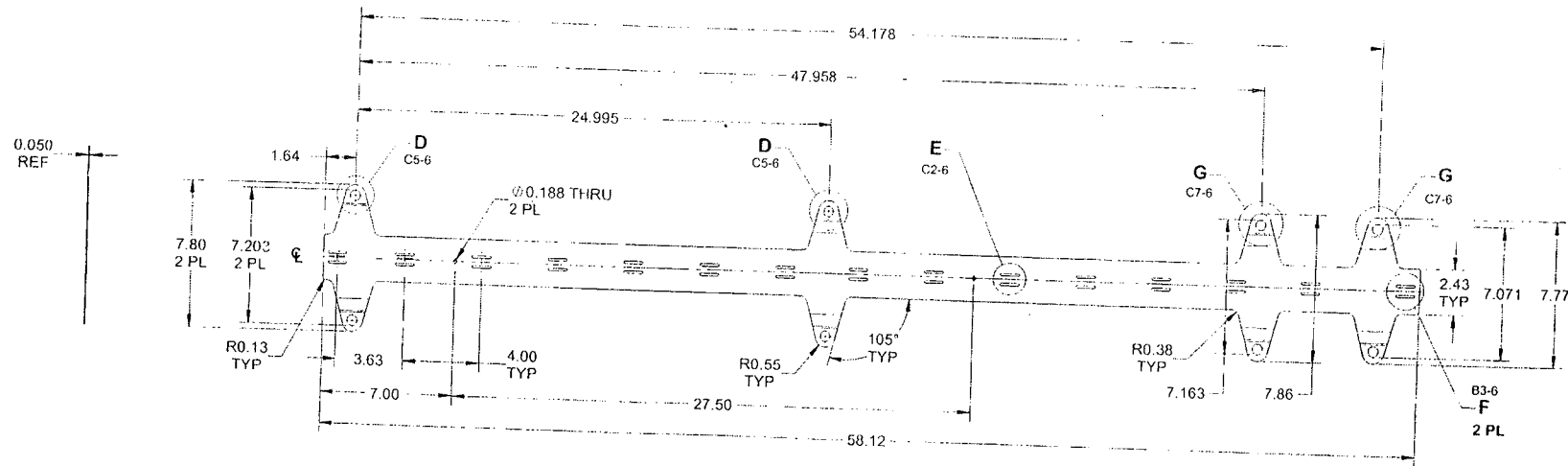
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

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MFG. APPR.	RF	D4406	SHEET 4 OF 6
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97011



D4406-3 PLATE
(MAKE FROM D4406-3F)



D4406-3F FLAT PATTERN

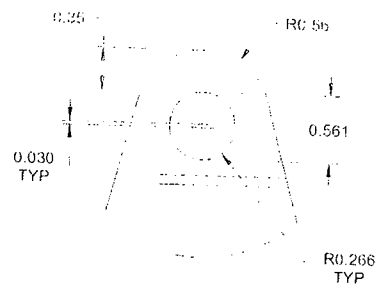
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.4 lbs

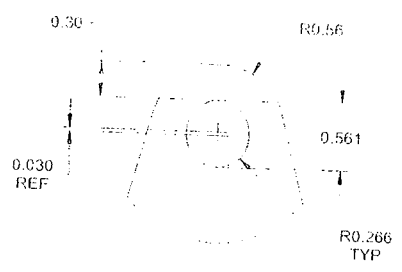
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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4406	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 6	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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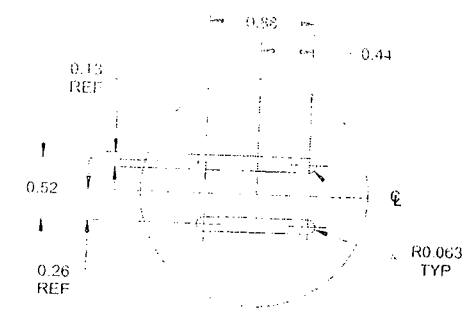
977el



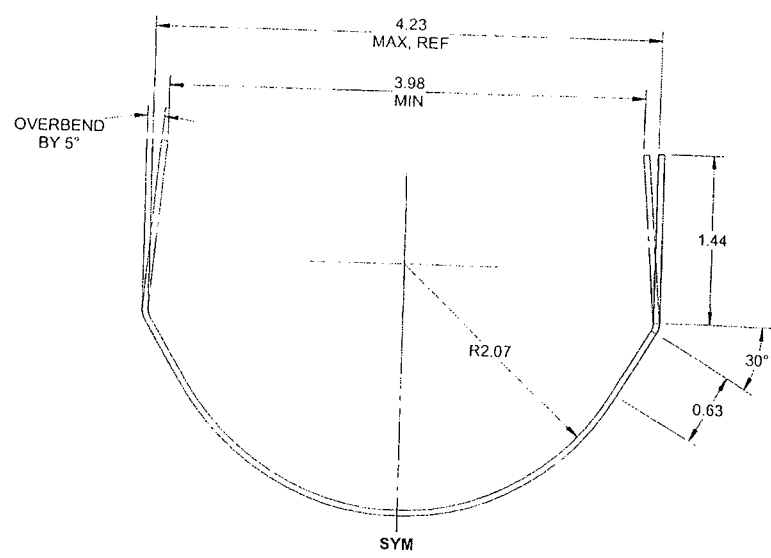
DETAIL G
SLOT DETAIL TYP
SCALE 6X
C7-4
C2-5
C3-5



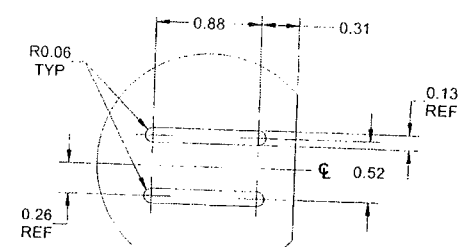
DETAIL D
SLOT DETAIL TYP
SCALE 6X
C2-4
C3-4
C5-4
C5-5
C6-5



DETAIL E
SLOT DETAIL TYP
SCALE 6X
C2-4
C4-5



DETAIL C
DETAIL TYP
SCALE 6X
D2-4
D6-5



DETAIL F
SLOT DETAIL TYP
SCALE 6X
C1-4
B1-5

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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